

Date: Monday, 02/03/2009 9:05:08 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STRUT WELDMENT ASS'Y
Job Number : 46143	
Estimate Number : 10554	
P.O. Number :	Part Number : D34431
This Issue : 02/03/2009 S.O. No. :	Drawing Number : D3443 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 41913	Material :
Written By :	Due Date : 16/03/2009 Qty: 12 Um: Each
Checked & Approved By : <u>JULIE DAWSON 03.02</u>	
Comment : A 05.11.14 New issue EC Est Rev:B Removed Tumbling 08-09-08 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

M174B2500X1250

17-4 SS BAR 2.500 x 1.250



Comment: Qty.: 0.2100 f(s)/Unit Total: 2.5200 f(s)
 Material: 17-4 SS Bar 2.500" X 1.250"
 (M17-4-B2.500x01.250)
 Batch: M110378

2.0

BAND SAW

BAND SAW



Comment: BAND SAW
 Cut blank 2.400 " long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA587 Rev: A1 & Dwg D3443 Rev: B

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:08 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASS'Y

Job Number: 46143

Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



12V

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Car

9/3/4

SLP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



12V

Comment: FINAL INSPECTION/W/O RELEASE

209/03/06

Job Completion



WLF 09-03-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD		Work Order: H6142
Description: Lug		Part Number: D3443-1
Inspection Dwg: D3443	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.000	+/-0.010	.997	✓			
0.342	+0.000/-0.005	.338	✓			
0.329	+/-0.010	.327	✓			
Ø0.500	+0.000/-0.005	.498	✓			
2.21	+/-0.030	2.217	✓			
Ø0.656	+0.000/-0.001	.655	✓			
0.625	+/-0.010	.627	✓			
0.95	+/-0.030	.951	✓			
2.230	+/-0.010	2.231	✓			
0.229	+/-0.010	.225	✓			
0.370	+/-0.010	.363				
0.525	+/-0.010	.524	✓			
0.524	+/-0.010	.524	✓			
0.390	+/-0.010	.388				
1.048	+/-0.010	1.048	✓			
0.05 x 45°	+/-0.5°	.05	✓			
R0.032	+/-0.010	.032	✓			
0.470	+/-0.010	.470	✓			
0.165	+/-0.010	.165	✓			
1/4-28UNF	N/A	1/4-28	✓			

Measured by: <i>SP</i>
Date: 09/03/03

Audited by: <i>SL</i>
Date: 09/03/04

Prototype Approval:	N/A
Date:	N/A

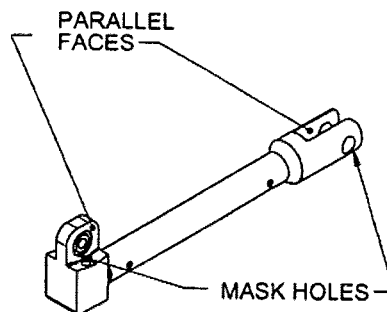
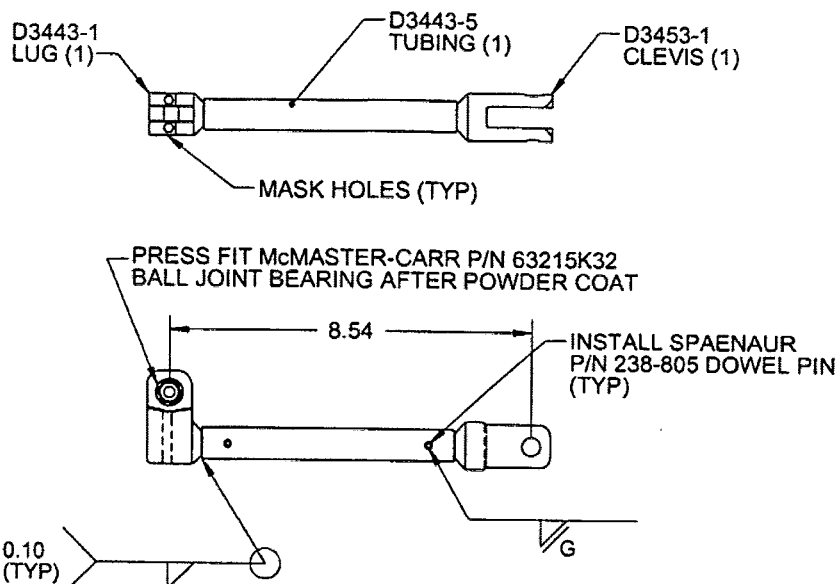
Rev	Date	Change	Revised by	Approved
A	06.07.11	New Issue	KJ/JLM <i>AK</i>	<i>BE</i>



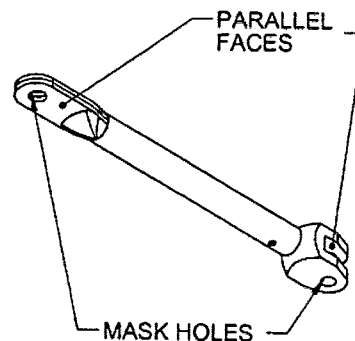
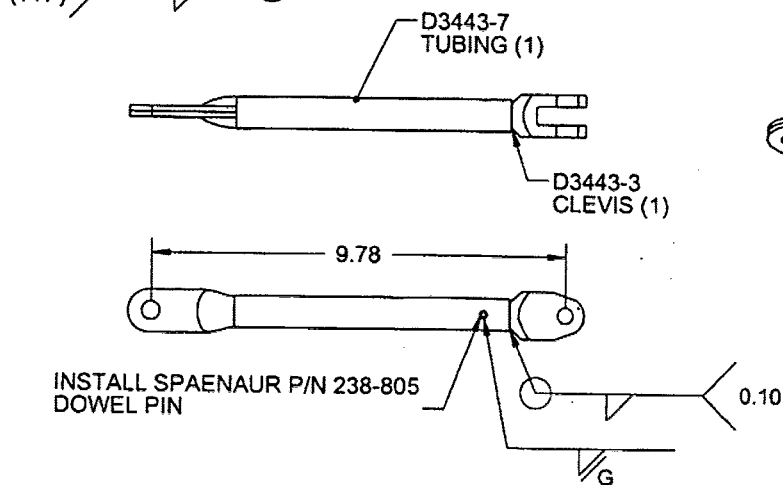
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:4		
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED

05.12.09 *[Signature]*



D3443-041



D3443-043

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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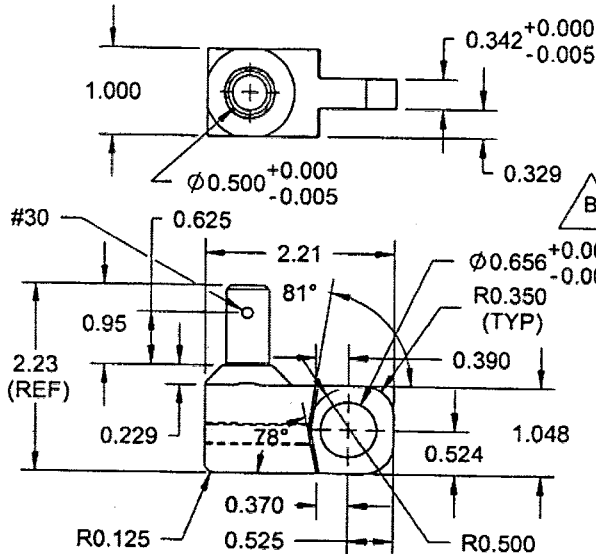
WORK ORDER
NO. *4643*

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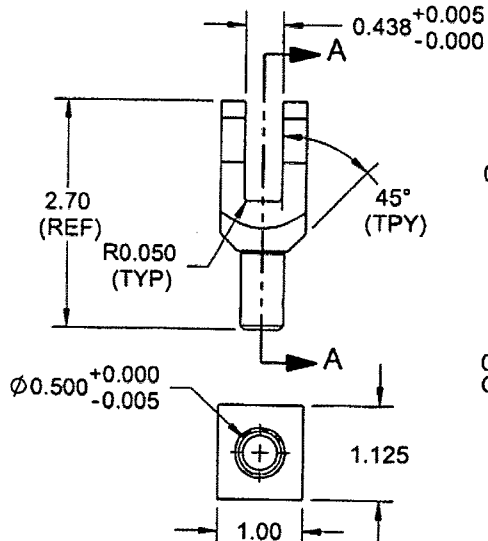
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 2 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

**D3443-1 NOTES:**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)

D3443-1 LUG**D3443-3 NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SECTION A-A**D3443-3 CLEVIS**

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NO. 210143

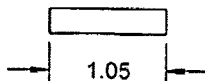
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY SCALE 1:2		

$\phi 0.210^{+0.005}_{-0.010}$



D3443-9 PIN

D3443-9 NOTES:

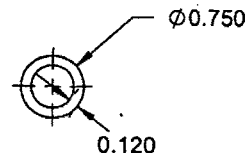
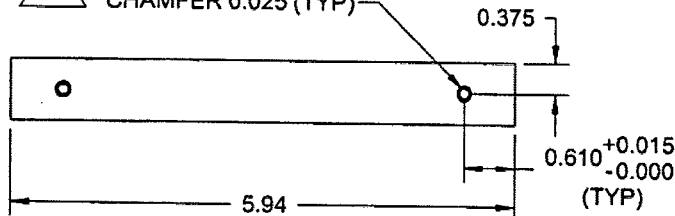
- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

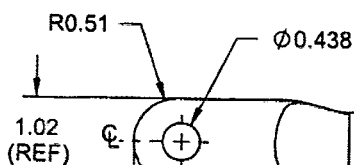
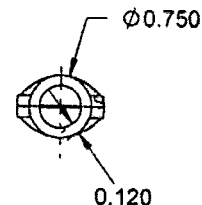
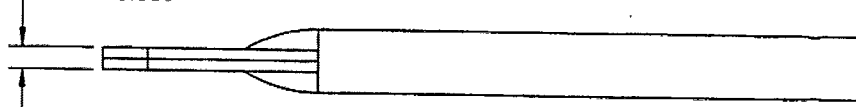


DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)



D3443-5 TUBING

$0.260^{+0.000}_{-0.030}$



DRILL $\phi 0.125$ THRU
CHAMFER 0.025

D3443-7 TUBING

D3443-5/-7 NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR 7500WT 120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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